

Work Order ID 54621

December 15, 2009 9:51:20 AM



Page 1

Item ID: D2596

Accept



Setup Start



Revision ID:

Stop



Item Name: Web, 205 Skidtube

Start Date: 14/12/2009 Start Qty: 4.00

5.00



Cust Item ID:

Required Date: 17/12/2009 Req'd Qty: 4.00

9-12-15



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 04-12-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2596

Rev D

100

0.00



Skidtubes

5

11/9/12/16

Skidtubes

Memo

0.00

Skidtubes

1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes
#30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr

110

0.00



Chemical Conversion Coat per QSI005 4.1

5

11/9/12/16

HandFinish

Memo

0.00

Hand Finishing

120

0.00



QC5- Inspect part completeness to step on W/O

27/8/12/16

QC

Memo

0.00

Quality Control

55

[Signature]

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Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: <u>Lb.</u> Memo	0.00 0.00				5	119/12/16		
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							09/12/17 11/09/12/14 (5)

Picklist Print

December 15, 2009 9:51:24 AM

Page 1

Work Order ID: 54621



Parent Item: D2596



Parent Item Name: Web, 205 Skidtube

Start Date: 14/12/2009

Required Date: 17/12/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin # Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	207.0000	4.0000			

Ext'n -1' Beam Web 4"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

207

40196

16

51957

191

5

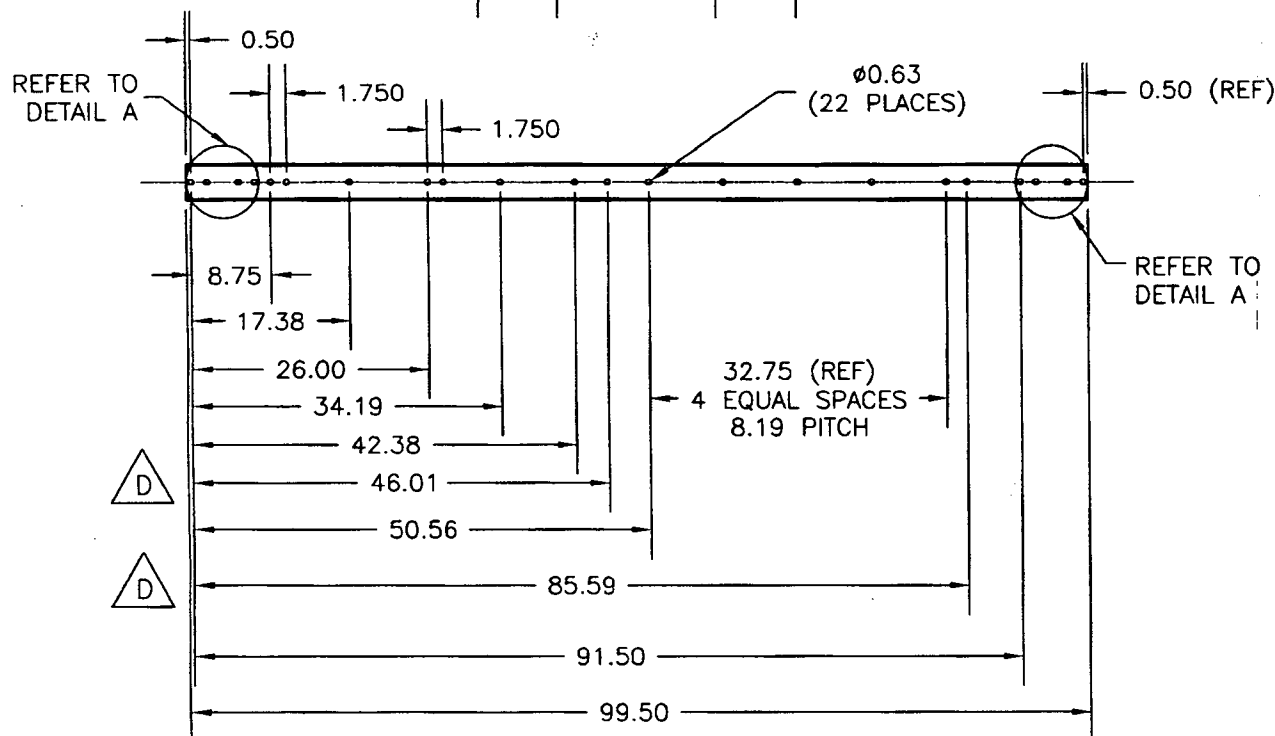
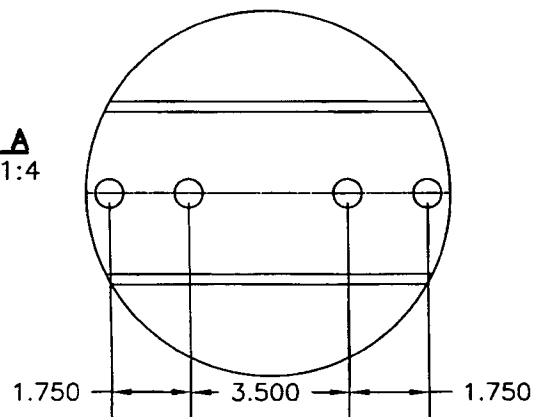
19/12/16



RELEASED
07 06 18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54621
P109-12-15

DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
04	04	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
		D2596	
DATE	TITLE	SCALE	
07.04.17	205 WEB	1:20	
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	